

Work Order ID 67463

Tuesday, March 22, 2011 8:22:04 AM

Page 1

Item ID: D3929-041

Accept

Revision ID:

Item Name: Gusset Assembly

Start Date: 3/22/2011 Start Qty: 6.00

Required Date: 3/30/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: 11-03-22 Tooling:

Date:



QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	Rev A								
100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3929								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

11-3-23

11-3-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3929-041

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Setup Start

Revision ID:

Stop

Item Name: Gusset Assembly

Start Date: 3/22/2011 Start Qty: 6.00

Required Date: 3/30/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/11/03/23

x2

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 115928

P/L 11.04.04

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

R/BE
11.04.05

7

φ

W/O:		WORK ORDER CHANGES					
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Work Order ID 67463

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Page 3

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 3/22/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10/06

(77)

not

170

Identify as per dwg & Stock Location:

0.00



Packaging

Bad lot call
Memo

0.00

Packaging

11.04.12 (7x)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13

11-04-13
(7)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 22, 2011 8:22:10 AM

Page 1

Work Order ID: 67463

Parent Item: D3929-041

Parent Item Name: Gusset Assembly





Start Date: 3/22/2011

Required Date: 3/30/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	31.0000	0.45	2.842105	3.5		
											1811-3-23		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT020				31			116623		
				116623				31					
D3907-1  Bushing		Manufactured	No			130	Each	83.0000	2	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				83					
				64273				1					
				65920				42					
				66090				40					

116623
12
11.04.04
12

W/O:		WORK ORDER CHANGES					
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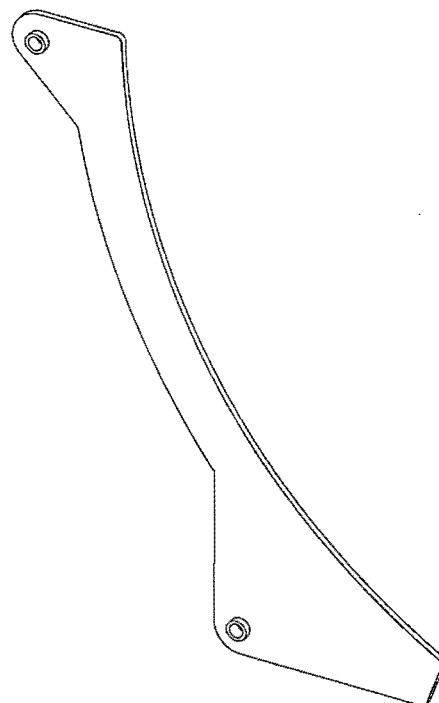
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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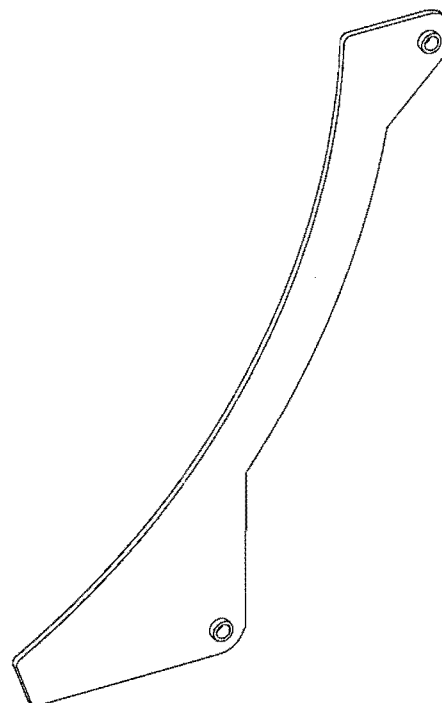
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62463

R/11-03-22

RELEASED
8/04/22 MD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3929	SHEET 1 OF 3
APPROVED			TITLE	SCALE
DE APPR.			GUSSET ASSEMBLY	NTS
DATE	09.04.03		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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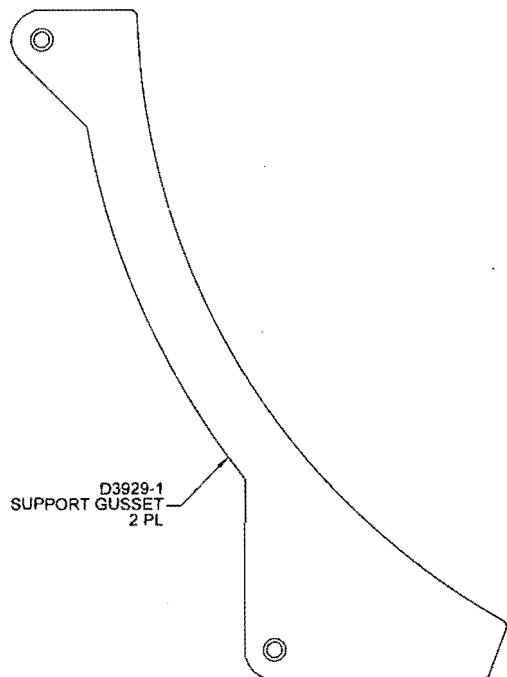
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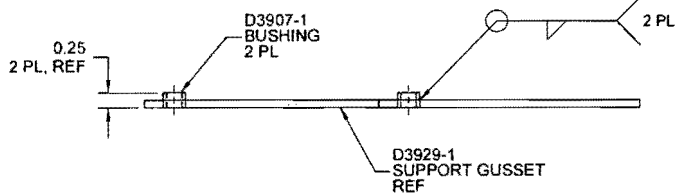
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3929-1
SUPPORT GUSSET
2 PL

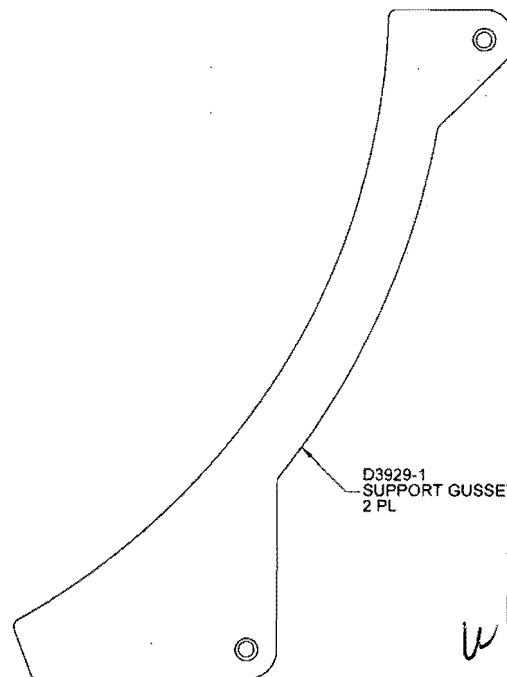


D3907-1
BUSHING
2 PL

D3929-1
SUPPORT GUSSET
REF

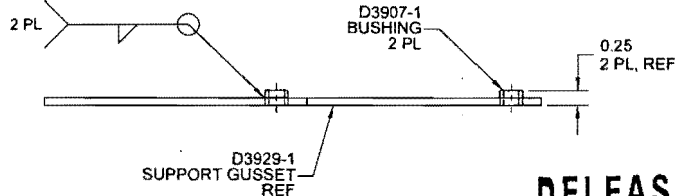
0.25
2 PL, REF

D3929-041 GUSSET ASSEMBLY



D3929-1
SUPPORT GUSSET
2 PL

W667463



D3907-1
BUSHING
2 PL

D3929-1
SUPPORT GUSSET
REF

0.25
2 PL, REF

D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/27 NTD

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	<i>BU</i>	DRAWING NO. D3929	REV. A
MFG. APPR.	<i>ND</i>	TITLE	SHEET 2 OF 3
APPROVED	<i>AMP</i>	GUSSET ASSEMBLY	SCALE
DE APPR.	<i>HT</i>		NTS
DATE	09.04.03	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

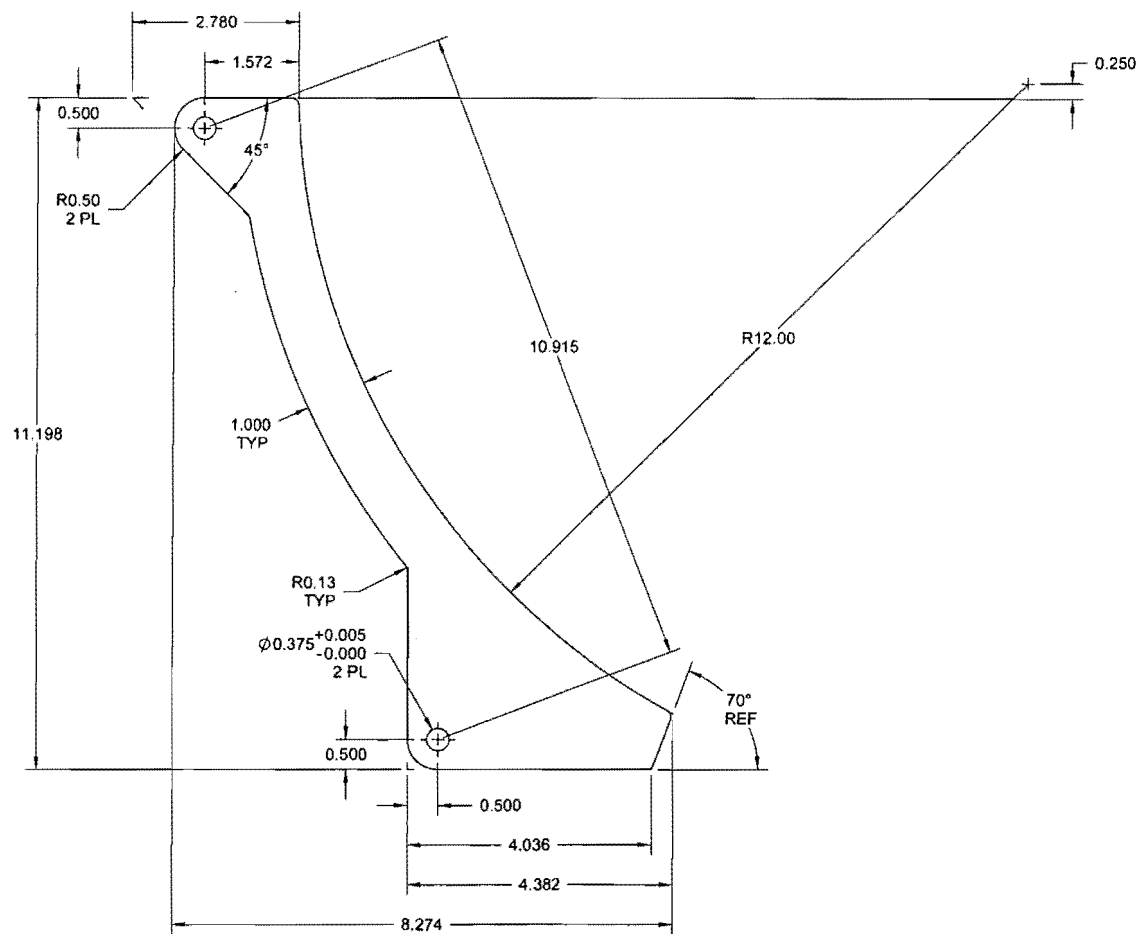
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NOTE: Date & initial all entries



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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RELEASED
09/04/2009

u6a7463

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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